

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009958**Date Inspected:** 20-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:****Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:****Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:****Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:****Yes No N/A****Delayed / Cancelled:****Yes No N/A****Bridge No:** 34-0006**Component:** OBG Trail Assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) S. Manjunath. Math was present during the times noted above for observations relative to the work being performed.

Orthotropic Box Girder (OBG) Trial Assembly Area

Signed Off Green Tag's

This Quality Assurance (QA) Inspector witnessed final tension verification for following depicted locations. Inspected 10% on a random basis and found the tension to be in general compliance and thus signed off the Green Tags.

At Segment 2AE at Panel Point 14, 15 and 16 for FL3 Bottom Plate to OBG Bottom Plate (CB1 Location) and Bolt Size used was M24 x 70 RC Set# DHGM240003 and final torque required was 543 N-m and Green Tag No. 388.

Note: Noticed 58 bolts of 6 rows in PP 14 and PP 16 installed and 40 Bolts of 4 rows in PP 15 were not installed due to shipment reasons.

At Segment 2AE at Panel Point 14, 15 and 16 for FL3 Bottom Plate to OBG Bottom Plate (CB1 Location) and Bolt Size used was M24 x 85 RC Set# DHGM240015 and final torque required was 517 N-m and Green Tag No. 389.

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### Ultrasonic Transverse Indication Evaluation

This QA Inspector Recorded the Y-Datum Line and the UT readings for the Transverse Segment to Segment weld “D” Scan as performed by Mr. Subhaish Bera, Mr. Stefan Holmes, Mr. Umesh Gaikwad and Mr. Christopher for the following Segment and generated the Ultrasonic Transverse Indication Evaluation Spread Sheet and Scatter Graph and submitted to Task Leaders for Review.

Segment 1AW-1AAW

Deck Panel with weld no. OBW1-001

Segment 1AW-1BW

Deck Panel with weld no. OBW1-006

Deck Panel with weld no. OBW1-007 (CW side)

Segment 1AE to 1AAE

Side Panel BK side with weld no. OBE1A-004 and OBE1A-005 (Y location had been changed for Oct 19, 2009)

Edge Panel BK side weld no. OBE1-003

Deck Panel with weld no. OBE1-009, OBE1-001 and OBE1-010

Segment 1AE to 1BE

Side Panel BK side weld no. OBE1A-010 and OBE1A-009

Side Panel CB side weld no. OBE1A-007 and OBE1A-006

Edge Panel CB side weld no. OBE1-004

Edge Panel BK side weld no. OBE1-008

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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## WELDING INSPECTION REPORT

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remedial efforts please contact , who represents the Office of Structural Materials for your project.

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**Inspected By:** Math,Manjunath

Quality Assurance Inspector

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**Reviewed By:** Carreon,Albert

QA Reviewer